

Date: Thursday, 5/3/2007 11:39:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y
Job Number : 32208	
Estimate Number : 12523	
P.O. Number : <i>N/A</i>	Part Number : D35313
This Issue : 5/3/2007 S.O. No. : <i>N/A</i>	Drawing Number : UNDER REVIEW <i>CB</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i>	Drawing Revision : <i>N/A</i>
Previous Run : 31172	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/28/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 3 Um: Each
Comment : Est Rev: A New Issue 06-09.06 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.1379 sf(s)/Unit Total : 0.4136 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *M/00 742**SAD 07/05/08*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: *Prel*Prog Rev: *Prel**SAD 07/05/08**(3)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/08**(3)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SAD 07/05/08**(3)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1




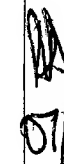
Deburr if necessary.

N/A Done @ Seq. 2.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/08	2.0	Program malfunction hole were to big (one part)	 05/04/2	Scrap destroy and replace	5/PM 07/05/08	 07/05/08	 05/04/2	 07/05/08

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:33 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 32208

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

3B 07/05/17

(3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20705-23 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD/SL

07/05/24 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD/SL 07/05/24 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST115

FD/SL 07/05/24 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD/SL 07/05/24 (3)

Job Completion



20705-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: ☒ Yes ☐ No DQA: _____ Date: _____

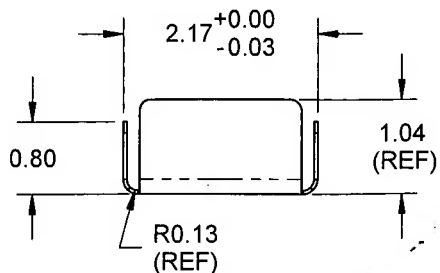
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.01.10	TITLE BRACKET.ASSEMBLY		SCALE 1:2

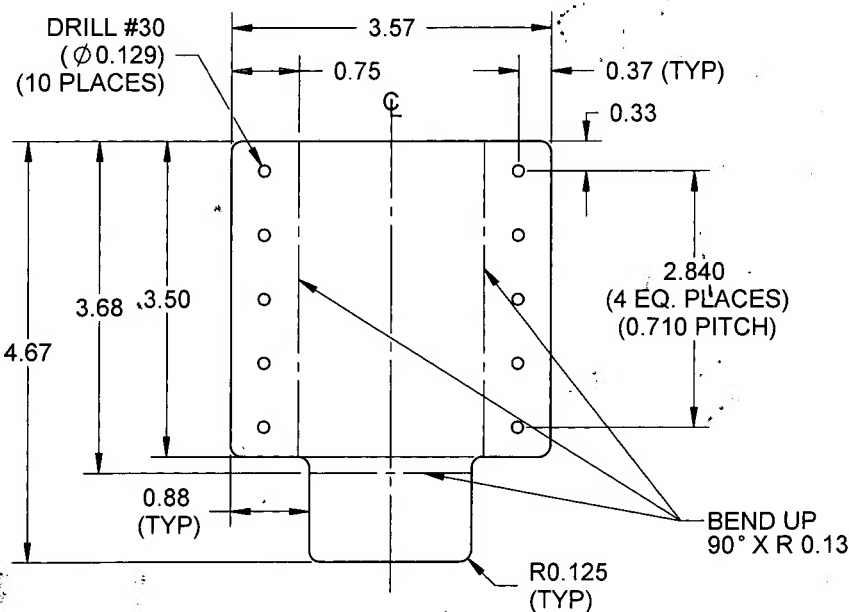
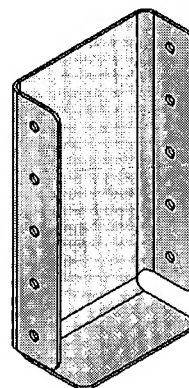


D3531-3 BEND DETAIL

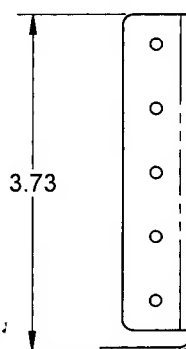
UNDER REVIEW

07.05.04 CB

Aug not released



D3531-3F FLAT PATTERN



D3531-3 BEND DETAIL

D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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WITHOUT NOTICE

WORK ORDER

NO 32208

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DART AEROSPACE LTD		Work Order: 32 208
Description: BRACKET ASS'Y		Part Number: D3531.3
Inspection Dwg: D35313 Rev: PREL		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.67	+/- 0.030	4.67	✓		Vern	
B 3.50	+/- 0.030	3.50	✓		Vern	
C 0.88	+/- 0.030	0.87	✓		Vern Vertical	
D 2.840	+/- 0.010	2.834	✓		Vern	
E 3.57	+/- 0.030	3.57	✓		Vern	
F 0.37	+/- 0.030	0.37	✓		Vern	
G 0.33	+/- 0.030	0.33	✓		Vern	
H 0.040	+/- 0.010	0.038	✓		Vern	
I 0.129	+0.005 -0.001	0.133	✓		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAM	Audited by: BF	Prototype Approval: [Signature]
Date: 07/05/08	Date: 07.05.08	Date: 07.05.08
Rev	Date	Change
		New Issue
		Revised by KJ/RF
		Approved